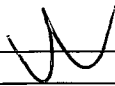
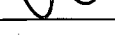


Date: Tuesday, 06/11/2007 11:43:30 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206667101
Job Number	: 35571		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: D206667101
This Issue	: 06/11/2007 S.O. No. : N/A	Drawing Number	: CHG 002
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 35413	Material	: N/A
Written By	: 	Due Date	: 13/11/2007 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1
 BUFF CUFFS, DRILL OEM HOLES PER CHG 002

EL 7-10-6

2.0	D206667101	Crosstube Installation
-----	------------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Crosstube Installation
 B16618

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5 7/12/07

4.0	SPRAY PAINTING	SPRAY PAINTING
-----	----------------	----------------



Comment: SPRAY PAINTING
 MASK AND
 RE-PRIME & REPAINT CUFFS

ml 07 12 05

(1)

5.0	QC14	INSPECT SPRAY PAINT
-----	------	---------------------



Comment: Inspect Spray Paint

25 07-12-07

6.0	D2873043	Nut Plate Assembly
-----	----------	--------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

33422

* 34061 min 2008/1/3

ml 07 12 04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/11/2007 11:43:31 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206667101

Job Number: 35571

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch
2 D2873-045 Nut Plate 34077

ml 07 12 04

8.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch
14 MS20601AD4W8 Rivet 105057

ml 07 12 04

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 07/12/07 (X1)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP

11.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

M105433

un-tenter

AS 07/12/07 (X1)

12.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

M103641

AS 07/12/07 (X1)

13.0

AN960JD516

Washer



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Washer

M104150

AS 07/12/07 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/11/2007 11:43:31 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206667101

Job Number: 35571

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Bolt

M104936(X) M105408(X1)

AS 07/12/01

(X1)

15.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Nut

M105430

AC 07/12/01

(X1)

16.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Washer

M104156

AS 07/12/07 SP

(X1)

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

207/12/11 (1)

Job Completion



207/12/11
min 2007/12/11 CY

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-141	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26

w/o 355H

UNDER REVIEW
06.08.10 PH
re-draw detail F

Qty	Part Number	Description
X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
1	D6001-105	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 93.18 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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Dart Aerospace Ltd

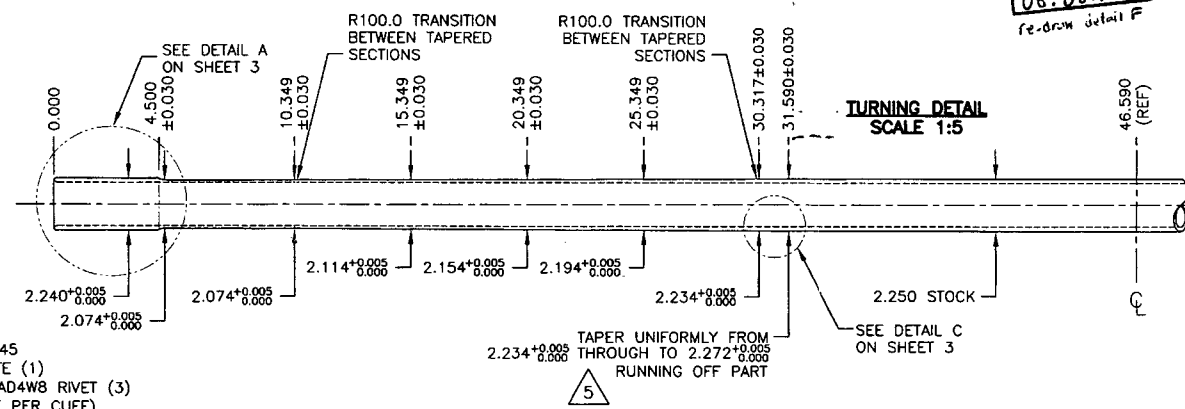
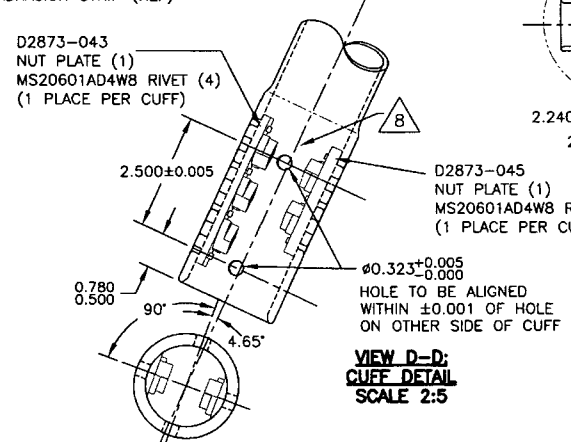
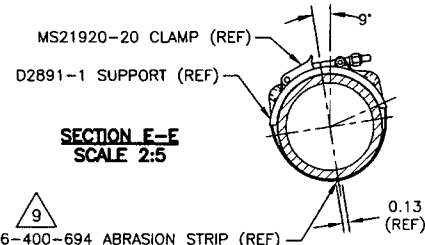
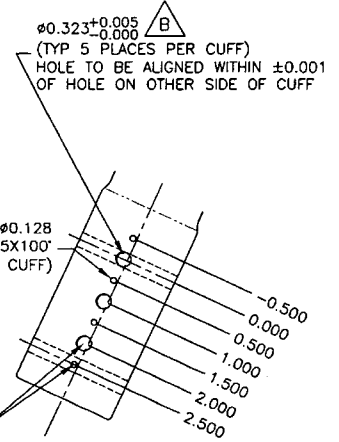
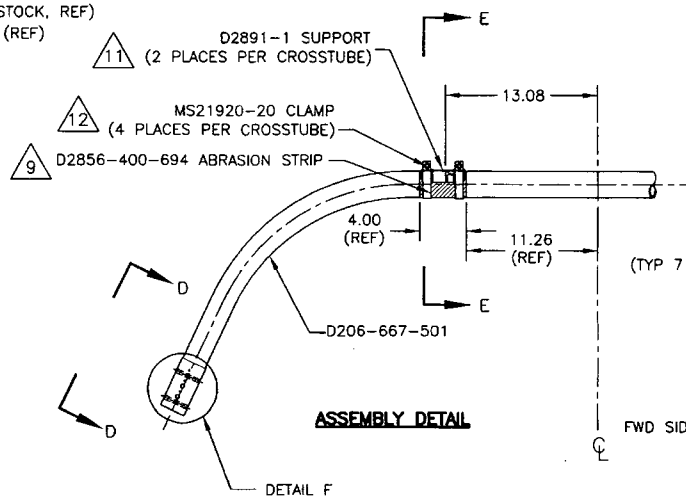
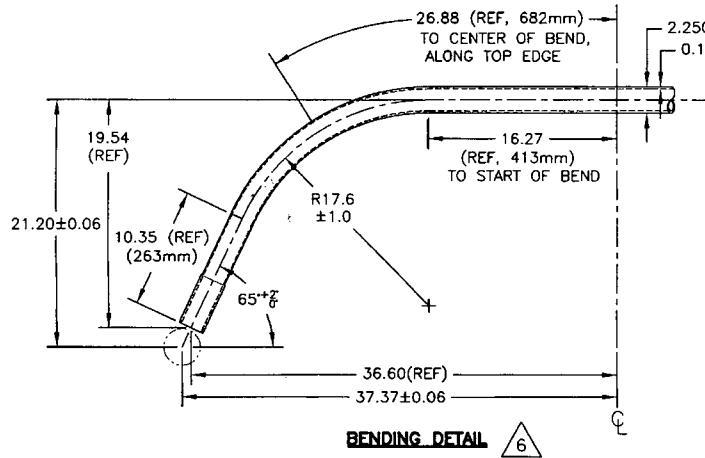
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



UNDER REVIEW
06.08.10 PH
re-draw detail F

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DATE		05.07.26	05.07.26	TITLE CROSSTUBE ASS'Y (206B HIGH FWD)	SCALE 1:10

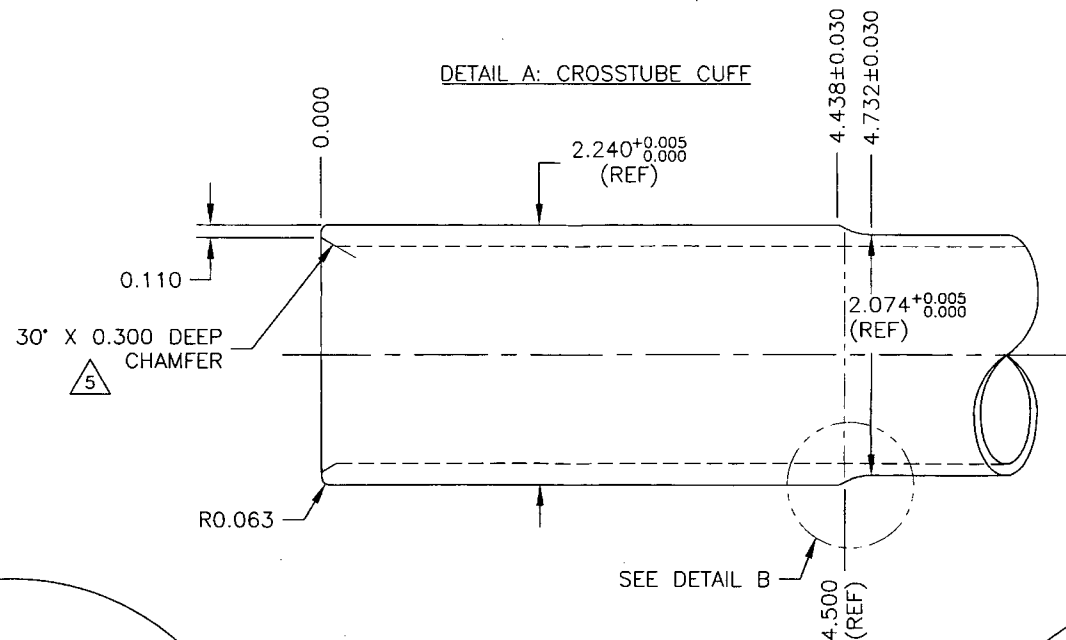
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

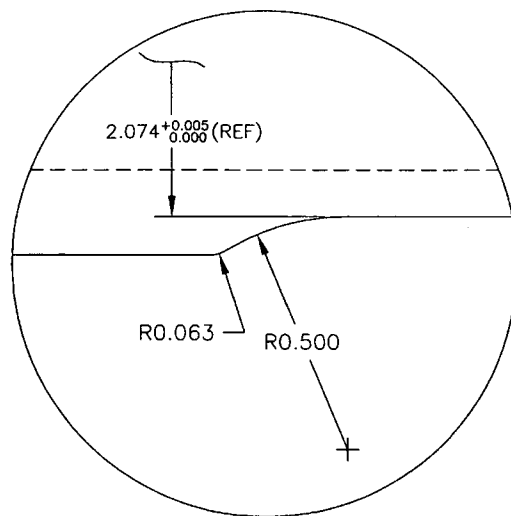
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



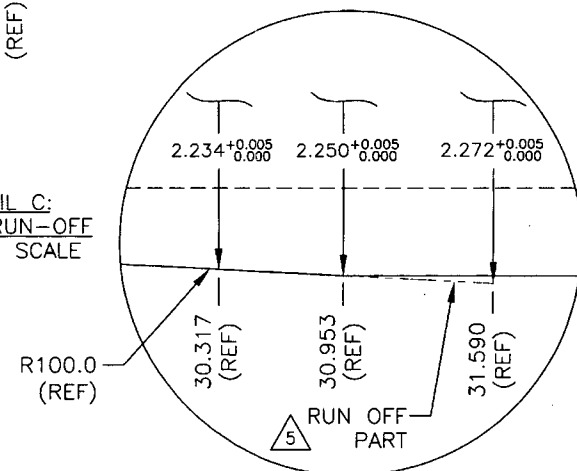
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06.08.10 PH
re-draw detail F

05.07.26



3/10/11
3541

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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		PH	PH		
		CHECKED	APPROVED	DRAWING NO.	REV. B
		DS	US	D206-667-141	SHEET 3 OF 3
		DATE		TITLE	SCALE
		05.07.26		CROSSTUBE ASS'Y (206B HIGH FWD)	1:1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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